

Ship. 07.21

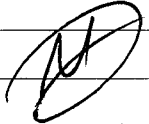
Work Order ID 164042

164042

Page 1

Tuesday, July 11, 2017 2:43:37 PM

Item ID: D3935-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pylon Wall Protector, LH
 Start Date: 7/14/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/19/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: JUL 11 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3935	B

100		0.00							
100									
Waterjet	Memo	0.18							
FLOW CNC Waterjet	1-Cut as per Dwg D3935								
	Dwg Rev: 								
	Prog Rev: 								
	2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									

DAS 19 9-89  SC 17/07/13

DAS 19 9-89  SC 17/07/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
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Page 2

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Revision ID:

Stop ***NS2***

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Start Date: 7/14/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/19/2017 Req'd Qty: 1.00 ***1***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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120 QC8- Inspect parts - second check 0.00

120

QC

Memo

0.02

Quality Control

DAS
38

9-89

JUL 13 2017

130 Identify as per dwg & Stock Location: PKG 0.00***130***

Packaging

Memo

0.01

Packaging

DAS
6
9-89

JUL 17 2017

~~JUL 18 2017~~

140 QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.10

Quality Control

DAS
21
9-89

JUL 17 2017

17/7/18

DQA: _____ Date: _____



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Work Order update only ☐

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Picklist Print

Tuesday, July 11, 2017 2:43:36 PM

Page 1

Work Order ID: 164042

164042

Parent Item: D3935-1

D3935-1

Parent Item Name: Pylon Wall Protector, LH

Start Date: 7/14/2017

Required Date: 7/19/2017

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased			No	100	sf	4,322.006	8.69	10.22353			
MI FXS 125-F60029-04									**			SC	7/10/13
GE PLASTICS LEXAN SHEET (DARK GREY)													

Location

Loc Qty

Loc Code

MAT018

4322.006

m136228

482.006

m137737

3840

10.23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

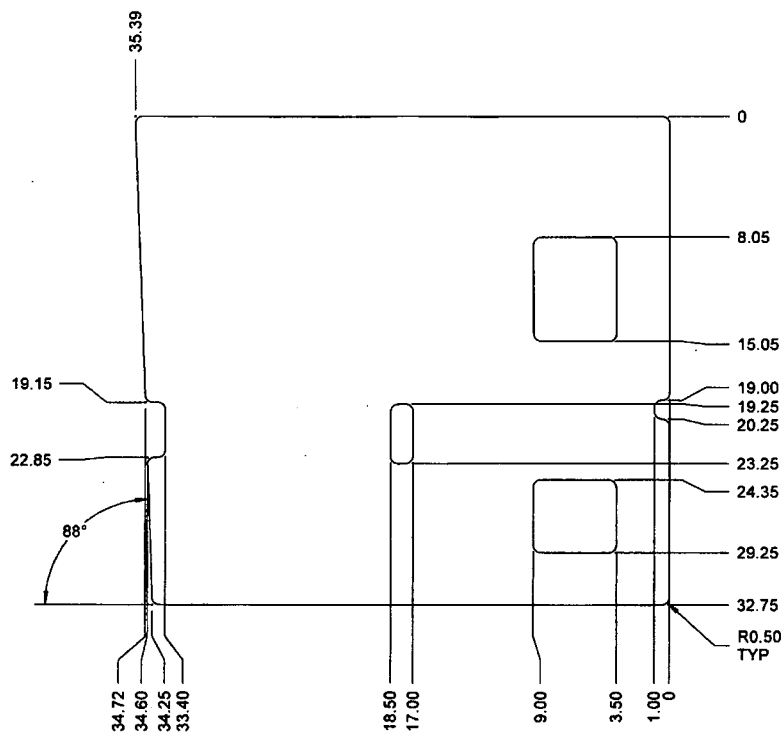
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Centre Not Concentric ☐	BOM/Route ☐																																																																			
Cracks ☐	Broken/Damage/Defect ☐																																																																			
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐																																																																			
Cuffs ☐	Contamination ☐																																																																			
Crushing ☐	Countersink ☐																																																																			
Heat Treat ☐	Cut Too Short ☐																																																																			
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐																																																																			
Marks/Chatter ☐	Drill Holes ☐																																																																			
Power Loss/Surge ☐	Positioned Wrong ☐																																																																			
Folio/Program ☐	Outside Dimensions ☐																																																																			
Grain ☐	Over/Under tolerance ☐																																																																			
Weld ☐	Part Incorrect ☐																																																																			
Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																			
Out of Sequence ☐	Part Moved ☐																																																																			
Off-set ☐	Drawing ☐																																																																			
Mislabeled ☐	Finish ☐																																																																			
Fit/Function ☐	Misread ☐																																																																			
Misaligned/off center ☐	Turning Sequence ☐																																																																			

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2009-10-22

D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

B	ADD -3, -4 (SHEET 3, 4)	09.08.19
A	NEW ISSUE	HS 09.04.21
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.08.19	
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